

Work Order ID 61541

Monday, August 30, 2010 10:39:10 AM



Page 1

Item ID: D206-559-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 8/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *H*

Date: 10-8-30 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-559

~~J-PRELIM Rev 1L~~

100 051 9507



DOCUMENT CONTROL

DC

Document Control

Memo

Photocopy bluefile and create labels per PPPD206-559-011 CHG0007 per een.

10-6-13
MF
10-9-15

160



Pick Kit

0.00

Sokolik

Packaging

Packaging

Memo

0.00

10/10/12 (4)

170



QC4- 100% Inspect kits for completeness

0.00

Sokolik

QC

Quality Control

0.00

(74)

W/O: 61541

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/12	100	Perm. Change update header box to current Rev + Add DSF. Fix CHG # PER ERN 10-613	SC	10/10/12			C 10/10/12

Part No: D206-559-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

**Sequence ID/
Work Center ID**

180



Packaging

Packaging

**Operation
Description**Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10/10/13
BSP

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/13
MF

10-10-13

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

Monday, August 30, 2010 10:39:15 AM

Work Order ID: 61541



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C 04.02.17 Blank size changed KJ/JLM

IPP Rev:D 07-01-02 Was K10007 JLM

IPP Rev:E 08-05-05 up a chg DD verified by:EC

IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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PAN4-17A 20A per DS F9527 6/10/10/12

<i>PAN4-17A</i>	<i>20A</i>	<i>per DS F9527</i>	<i>6/10/10/12</i>	Purchased	No		160	Each	375.0000	8	32	<i>M114016</i>	<i>✓</i>
-----------------	------------	---------------------	-------------------	-----------	----	--	-----	------	----------	---	----	----------------	----------

6+ Bolt

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>									
	ST	112										
	115374	112										
	ST338	112										
	ST358	263										
	114784	21										
	115108	142										
	115371	100										
<i>PAN4-17A</i>	<i>20A</i>	<i>per DS F9527</i>	<i>6/10/10/12</i>	Purchased	No		160	Each	536.0000	8	32	<i>✓</i>

S+ Bolt

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>								
	ST359	536									
	112314	536									
<i>AN960JD4T6</i>	<i>NAS1149D0463J</i>	<i>Purchased</i>	<i>No</i>			160	Each	0.0000	16	<i>M112314</i>	<i>✓</i>

6+ Washer

<i>AN960JD4T6</i>	<i>NAS1149D0463J</i>	<i>Purchased</i>	<i>No</i>			160	Each	0.0000	16	<i>M115647</i>	<i>✓</i>
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W/O: 61541		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/12	A 100	Perf. change update to DS7 9527 with b) Remove A/N4-15 & Bolts and replace with A/N4-20A Bolt 2 1/4 x 8 PCF 12.9	ER	10.10.12			S 10/10/12	

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Picklist Print

Page 2

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Work Order ID: 61541



Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

D2182B



Rubber Cushion

Manufactured No

160

f

215.1285

1.666

6.664 ✓



B45405 4.00 ✓

Location	Loc Qty	Loc Code
ST402A	26.07	
	30872	
	39986	
ST410	189.05854	
	52649	52649 2-17

(D2182B050) Cut (4) at 5.00" as per dwg ***per kit***

D2274



Radius Block

Manufactured No

160

Each

168.0000

8

32



51427 12X ✓

52644 4X
54850 8X
55168 8X

D2435



Bearpaw, 206

Manufactured No

160

Each

0.0000

2

8



B61536 ✓

D2438



Clamp

Manufactured No

160

Each

228.0000

4

16



B52645 11X ✓ 10/14/12

Location	Loc Qty	Loc Code
ST456	228	
	59123	
	60852	

59123 5X

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Parent Item: D206-559-011



Parent Item Name: Bearpaw

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 4.00

Required Qty: 4.00

D2529



Washer

Manufactured

No

160

Each

166.0000

8

32



B52740 12 X

[Signature]

MS21042L4



Nut

Purchased

No

Location

ST017

Loc Qty

166

Loc Code

58568

166

8



58568 24
32 C

[Signature]

QS200-M44S



Clamp

Purchased

No

160

Each

32.0000

2



M116108
8 C

[Signature]

Location

ST450

Loc Qty

32

Loc Code

114917

12

115410

20

114917

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REFERENCE ONLY

8

5.0 PARTS LIST (D206-559 REV. K)
32.7 PARTS LIST (ICA-D205-559 REV. 2)

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
6		6					D2732-050	RUBBER CUSHION
					2		D3456-1	WASHER
						2	D3859-041	WEARPLATE
					2		D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A'	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
					8	12	NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-0-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.06.30
CERT. NO.:	SH92-17
ISSUE NO.:	7

DESIGN	<i>gp</i>	DART AEROSPACE LTD	
DRAWN	<i>gp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>1</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	BOLT CHANGE	
DATE	10.06.30	NTS	
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